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IN THE CLAIMS:

1. (currently amended) A process of producing an inner profile ~~(18)~~ in a tube or hollow profile ~~(11)~~ comprising:
inserting the tube or hollow profile ~~(11)~~ into a supporting sleeve ~~(12)~~, with a first tube end ~~(19)~~ being axially supported;
placing a pressure-loaded annular die ~~(16)~~ on to ~~the other~~ a second tube end ~~(20)~~;
pressing a forming die ~~(15)~~ with an outer profile into the tube or hollow profile ~~(11)~~ from the ~~latter~~ second tube end ~~(20)~~ for producing the inner profile ~~(18)~~; and
allowing a return of the annular die ~~(16)~~ under a pressure load in the opposite direction of that of pressing in the forming die ~~(15)~~.
- 2.-5. (cancelled)
6. (new) A process according to claim 1, wherein a pressure load on the annular die is reduced with an increasing return path.
7. (new) A process according to claim 6, wherein the pressure load on the annular die is reduced in such a way that the sum of an integrated wall friction between the tube or hollow profile and the supporting sleeve in the region of deformation, and the pressure load on the annular die remains approximately constant.
8. (new) A process according to any one of claim 1, wherein the inner profile is a splined shaft profile.
9. (new) A process according to any one of claim 6, wherein the inner profile is a splined shaft profile.

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10. (new) A process according to claim 1, wherein the inner profile is a ball track profile.

11. (new) A process according to claim 6, wherein the inner profile is a ball track profile.

12. (new) A process according to claim 1, wherein the second tube end is only radially supported by the sleeve.

13. (new) A process according to claim 1, wherein the supporting sleeve is axially longer than the tube or hollow profile.

14. (new) A process according to claim 1, wherein the annular die retracts during the step of pressing in response to a backward flow of material.

15. (new) A process according to claim 1, wherein the annular die and pressing die are coaxially arranged.

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